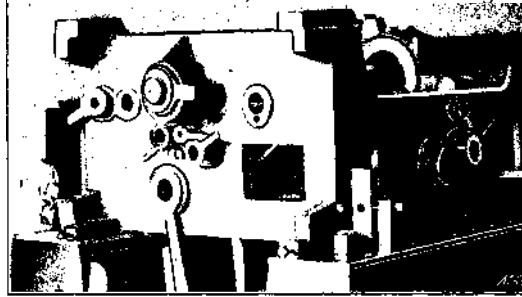


Fig. 14. Combined Drilling and Boring Jig used with, a Horizontal Drilling and Boring



part *I* close to the bracket during the boring operation, as illustrated, accurate results will be obtained. It is evident that two of the bearings could be bored out by using the finished bearing and the traveling part *I* as guiding means. Arrangements of this kind usually save expensive tools, and often give better results.

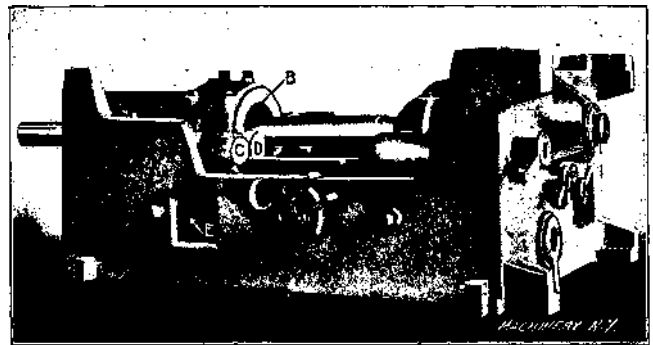


Fig. 15. Another View of the Jig in Fig. 14 — Note that Holes **are** drilled or bored from all Sides

Combination Drill and Boring Jig. — Jigs for performing both drilling and boring operations are frequently used to great advantage. Combination jigs are sometimes used, however, when the operations can be more easily performed in two separate jigs. For some classes of work it is advisable to have a jig for the boring alone; the bored holes are then used for